

Work Order ID 60470

Monday, July 12, 2010 1:16:37 PM



Page 1

Item ID: D2581

Accept



Setup Start



Revision ID:

Item Name: Mounting Bracket

Stop



Start Date: 7/12/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 7/16/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-7-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2581	Rev A1

100 FLOW WATER JET 0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2581

Dwg Rev: A1

Prog Rev: A1

2-Deburr if necessary

mm 10 - 07 - 13 (20)
B 10-7-21 (20)

110 QC2- Inspect parts off machine FAI/FAIB 0.00



QC

Memo

0.00

Quality Control

mm 10 - 07 - 13 (20)
B 10-7-21

Pho →

120 QC8- Inspect parts - second check 0.00



QC

Memo

0.00

Quality Control

S. 10/12/22

counts
(+35)
(+30)
(+3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2581 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Yes Date: 10/07/19
 Resolution: _____ Disposition: _____ QA: N/C Closed: Yes Date: 10/07/28

NCR: <u>60470</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/07/19	# 100	Found at inspection qty x5 Parts with the hole pattern off. (too close to edge) and too thick .750" measure .711"		→ Scrap + Destroy qty x5 Replay m <u>114799</u> qty x20	FB 10-7-27	S 10/07/19		S 10/07/19
		Rel. Parts move on when Being water taken. Process		/	/	/	/	S 10/07/19

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 7/16/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00		SB		(35)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		10/07/14		(35)			
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00		SAP		(35)			

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Revision ID:

Item Name: Mounting Bracket

Stop



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Cust Item ID:

Required Date: 7/16/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/28 JF

pl 10-7-28
35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 60470

Parent Item: D2581

Parent Item Name: Mounting Bracket




Start Date: 7/12/2010

Required Date: 7/16/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP D001.07.17 Added info to step 2 SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	119.1582	0.0187	0.393684			



Location

MAT

Loc Qty

119.1582

1.5259

117.6323

Loc Code

~~114488~~

114799

M 10.07.13

114799 FB 10-7-21

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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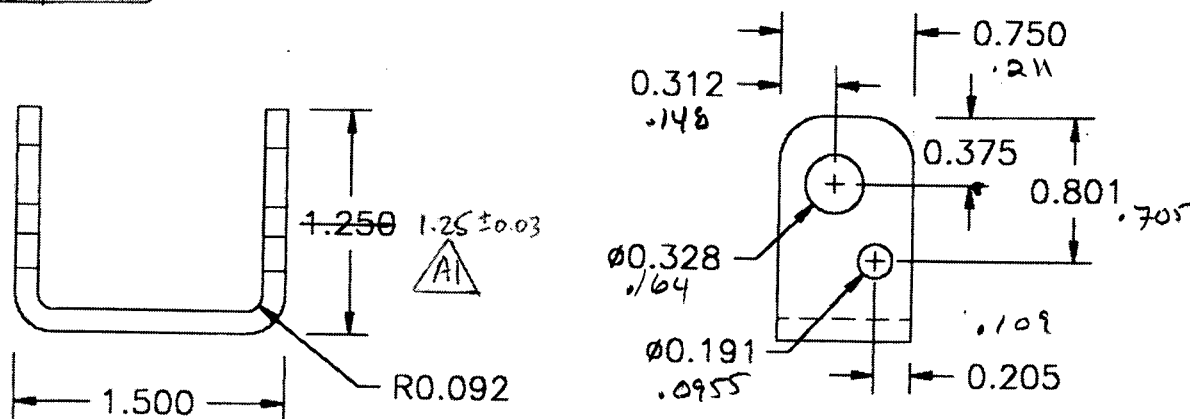
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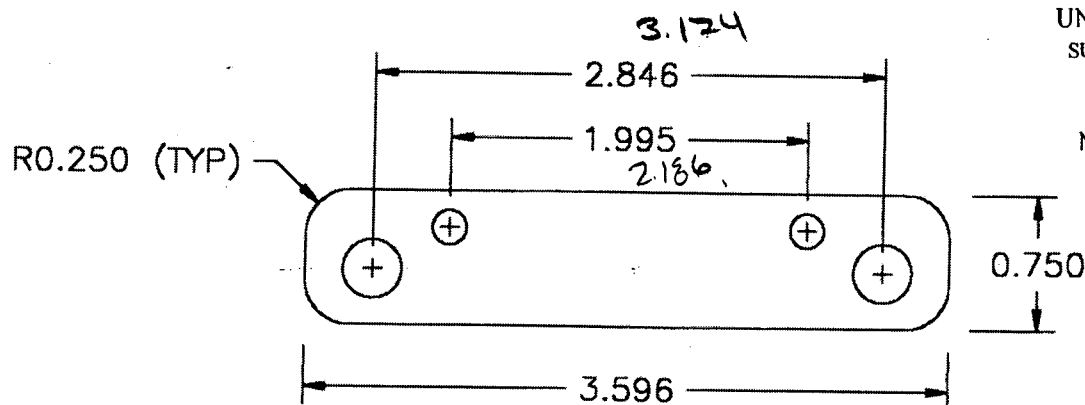


DESIGN		DRAWN BY		DART AEROSPACE LTD	
MIKE M		MIKE M		VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. A	
<i>BW</i>	<i>M. M.</i>	D2581		SHEET 1 OF 1	
DATE		TITLE		SCALE	
96.06.27		MOUNTING BRACKET		1:1	
AI	<i>#</i>	<i>CP 04.05.14</i>		CHANGE TOLERANCE ON 1.25 DIMENSION	

RELEASED
960723 Bw



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60470



MATERIAL: 304/316 SS 0.125 THICK